

016058



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PRIORITY

644.0205

Job Sheet 209941



Part No: 644.0205

Job Qty: 4 pcs

Part Name: Inner Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/19/20

Job Tracking No:

Due Date: 6/5/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: 644.0200 REV.G IPP REV:A 2020.05.15 NEW ISSUE DD VERF:JFS

Ship Via:

MUST SHIP
ON OR BEFORE
JUNE 10

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Conventional Mill - 1	4			15.00	2.00	Conventional Mill - 1		
		pcs					Conventional Mill - 2		
120	QC 2	4			0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S279099



Part: 644.0205

Job No: 209941

Serial No/Batch: S279099

Revision: REV.G

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Email: sales@dartaero.com
www.dartaero.com

Date:

			QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 2 - 86	
			QC 2 - 83	
130 QC 8	4 pcs	0.00 0.00	QC 8 - 12	Onk 20/05/23
			QC 8 - 14	
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
			QC 8 - 66	
			QC 8 - 73	
			QC 8 - 82	
140 Outsource - 4 - Anodize	4 pcs	0.00 0.00	ATG001	2020-05-25
150 Packaging 2-1 - Receive - B4B	4 pcs	0.00 0.00	Packaging 2 - 1 - B4B	MAY 28 2020
			Packaging 2 - 2 - B4B	
			Packaging 2 - 3 - B4B	
			Packaging 2 - 5 - B4B	
			Packaging 2 - 4 - B4B	
			Packaging 2 - 6 - B4B	
			Packaging 2 - 7 - B4B	
			Packaging 2 - 8 - B4B	
			Packaging 2 - 9 - B4B	
			Packaging 2 - 10 - B4B	
			Packaging 2 - 11 - B4B	
			Packaging 2 - 12 - B4B	
			Packaging 2 - 13 - B4B	
			Packaging 2 - 14 - B4B	
			Packaging 2 - 15 - B4B	
			Packaging 2 - 16 - B4B	
			Packaging 2 - 17 - B4B	
			Packaging 2 - 18 - B4B	
			Packaging 2 - 19 - B4B	

			Packaging 2 - 20 - B4B	
			Packaging 2 - 21 - B4B	
			Packaging 2 - 22 - B4B	
			Packaging 2 - 23 - B4B	
			Packaging 2 - 24 - B4B	
			Packaging 2 - 25 - B4B	
			Packaging 2 - 26 - B4B	
			Packaging 2 - 27 - B4B	
			Packaging 2 - 28 - B4B	
			Packaging 2 - 29 - B4B	
			Packaging 2 - 30 - B4B	
			Packaging 2 - 31 - B4B	
			Packaging 2 - 32 - B4B	
			Packaging 2 - 33 - B4B	
			Packaging 2 - 34 - B4B	
			Packaging 2 - 35 - B4B	
			Packaging 2 - 36 - B4B	
			Packaging 2 - 37 - B4B	
160 QC 6	4 pcs	0.00 0.00	QC 6 - 9	
			QC 6 - 68	
			QC 6 - 61	DAS
			QC 6 - 40	81
			QC 6 - 81	9-89
			QC 6 - 82	
170 Spray Paint - 2 - B4B	4 pcs NR	0.00 1.33	Spray Paint - 1 - B4B	
			Spray Paint - 2 - B4B	
			Spray Paint - 3 - B4B	DAS
			Spray Paint - 4 - B4B	21
				9-89
180 QC 14	4 pcs NR	0.00 0.00	QC 14 - 15	
			QC 14 - 2	
			QC 14 - 34	
			QC 14 - 41	
			QC 14 - 51	DAS
			QC 14 - 58	21
			QC 14 - 59	9-89
			QC 14 - 9	
			QC 14 - 68	
			QC 14 - 40	
			QC 14 - 19	
			QC 14 - 43	
			QC 14 - 24	
			QC 14 - 61	
			QC 14 - 81	
			QC 14 - 82	
			QC 14 - 87	
190 Small Fab - 2 - B4B	4 pcs	0.00 0.67	Small Fab - 1 - B4B	
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	JUN 01 2020
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
200 QC 5	4 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	

			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
210 Packaging 3-1 - Stock - B4B	4 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
220 QC 21 - SA	4 pcs	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70	
Part Op 110 - Cut blanks to 1.00" 1-Machine as per dwg DWG REV: <u>G</u> 2-Deburr Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check				

140 - Issue P/O: 46484 AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 Certification of Conformity is required
 150 - Receive & Inspect for Damage & Mat'l Certs
 160 - QC6- All purchased or subcontracted products
 170 - PRIME PRIMER IAW MIL-PRF-23377 TYPE 1 CLASS N BATCH: _____
 180 - QC14- Inspect Spray Paint
 190 - INSTALL NUTPLATE AS PER DWG
 200 - QC5- Inspect part completeness to step on W/O
 210 - Identify as per dwg & Stock
 220 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3A1.0X1.5X125	Angle 2024T3511 1.0x1.50x .125w	.3332 ft (.0833 ea)	110-Conventional Mill - 1	FM 134656
MS20426AD3-4	Rivet	8 Ea (2 ea)	190-Small Fab - 2 - B4B	FM 136444-2.
MS21076L04N	Self Locking Nutplate	4 (1 ea)	190-Small Fab - 2 - B4B	3279062.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Conventional Mill - 1	M2024T3A1.0X1.5X125	0	13	0
190-Small Fab - 2 - B4B	MS20426AD3-4	8	1,004	0
	MS21076L04N	4	0	0

Part Specifications

Specifications could not be found.

Plex 5/19/20 10:10 AM dart.lacelle.linda

GA006
ST298

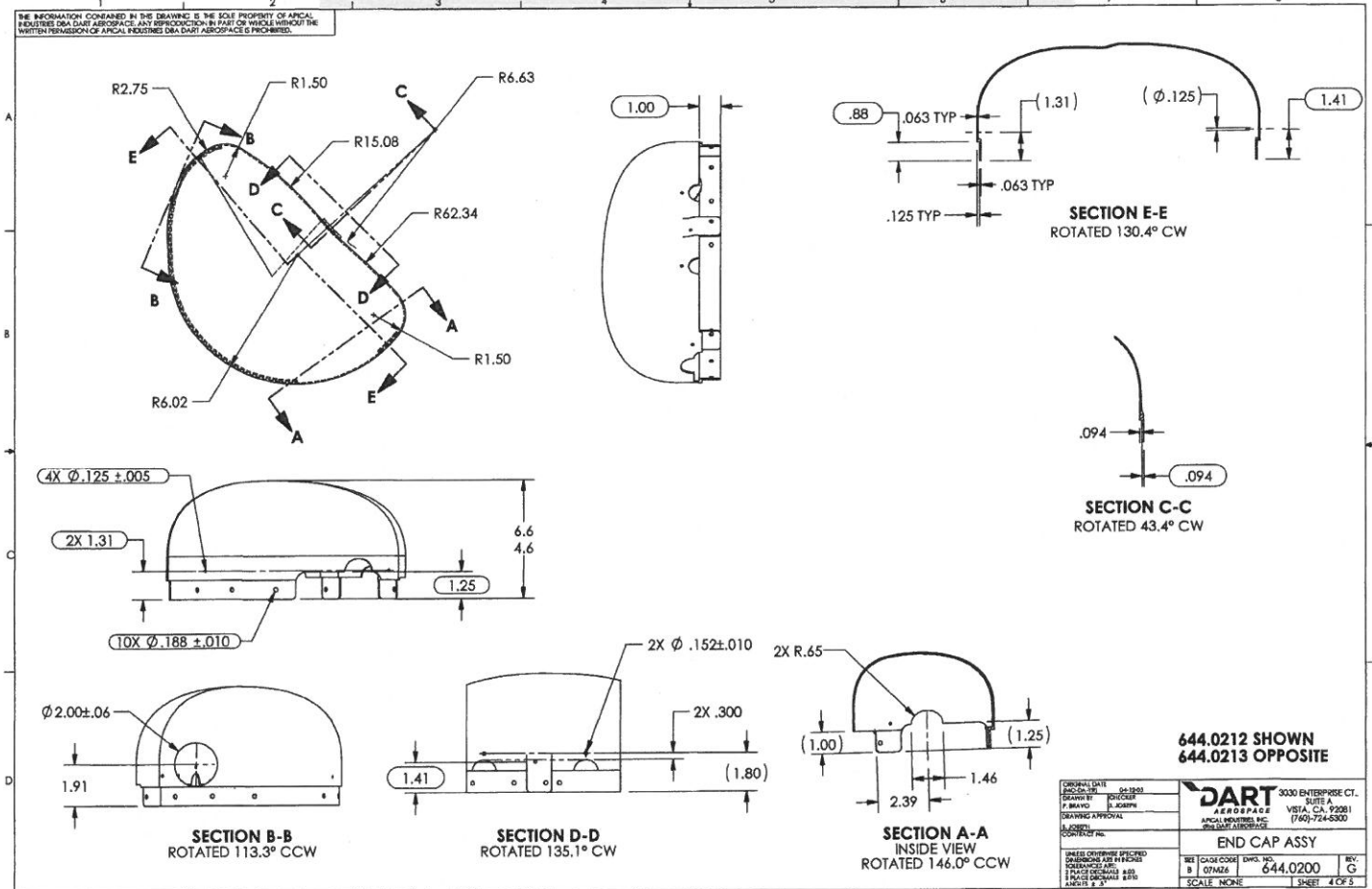
 SURFACE COATING: PROTECTIVE WAX COATING

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	INCORP FCW 01162, 01134, 01161 & 01917	08/16/87	S. JOSEPH
B	INCORP FCW 02110 & 02966	01/23/90	P. BRAVO
C	INCORP FCW 03085	03/08/93	P. BRAVO
D	INCORP FCW 03706	04/05/93	P. BRAVO
E	INCORP FCW 03778 & 06272	12/02/95	P. BRAVO
F	INCORP FCW 05787	06/23/97	P. BRAVO
G	INCORP FCW 05789 & 06240	09/25/97	P. BRAVO

			A/R	A/R	A/R	A/R	20			THREAD		Y-129A REF
			A/R	A/R	A/R	A/R	19			600.0901	LA 4009	
2	2	2					18			601.1710	RIVET	MS20454-023-4
1	1	1					17			601.2180	NUT/PLATE	A62016-040-0
			1	1	1	1	16			644.0221	DOUBLER	
			1	1	1	1	15			644.0220	DOUBLER	207 X 38P 100 227 X 47D
			A/R	A/R	A/R	A/R	14			601.2045	RTV, BLACK	LOCITE 998
			1	1	1	1	13			644.0219	CLEAR PLASTIC	AN X 40N 10 A66 X 26G15
				2	2	2	12			644.0218	CLEAR PLASTIC	
			10	10	10	10	11			600.0543	EYELET	A627700-108
			10	10	10	10	10			600.0513	STAP	BLACK
			07D0	07D0	07D0	07D0	9			600.0492	VELCRO, 1" HOOK	MS2790-75 WATERFAST TITN
							8			644.0217	UPPER BRACKET	
1							7				DELETED	
							6			644.0215	UPPER BRACKET	
							5			644.0214	INNER BRACKET	
							4			644.0213	RU AFT END CAP	
							3			644.0212	LH AFT END CAP	
							2			644.0211	RH FWD END CAP	
					1	1	1			644.0210	LH FWD END CAP	
							1			644.0207	UPPER BRACKET ASSY	
							1			644.0206	OUTER BRACKET ASSY	
							1			644.0205	INNER BRACKET ASSY	
							1			644.0204	RH AFT END CAP ASSY	
							1			644.0203	LH AFT END CAP ASSY	
							1			644.0202	RH FWD END CAP ASSY	
							1			644.0201	LH FWD END CAP ASSY	
0207	0206	0205	0204	0203	0202	0201	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.	

NEXT ASSY IS 444.0500	ORIGINAL DATE 10-20-84	BY B-2305	 3030 ENTERPRISE CT. VISTA, CA 92081 (760)-724-5300
	DESIGNED BY R. BRALVO	BY J. JOHNSON	
CONSTRUCTION APPROVAL S. JOHNSON	DATE 06-13-86		
CONTACT IN CH.			
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES 1/8" MINIMUM ALL DIMENSIONS 1/4" MINIMUM ALL DIMENSIONS 1/2" MINIMUM ALL DIMENSIONS			END CAP ASSY
REF. CAGE CODE 644.0200 644.0200			DWG. NO. 644.0200 644.0200
REV. 1 OF 5			

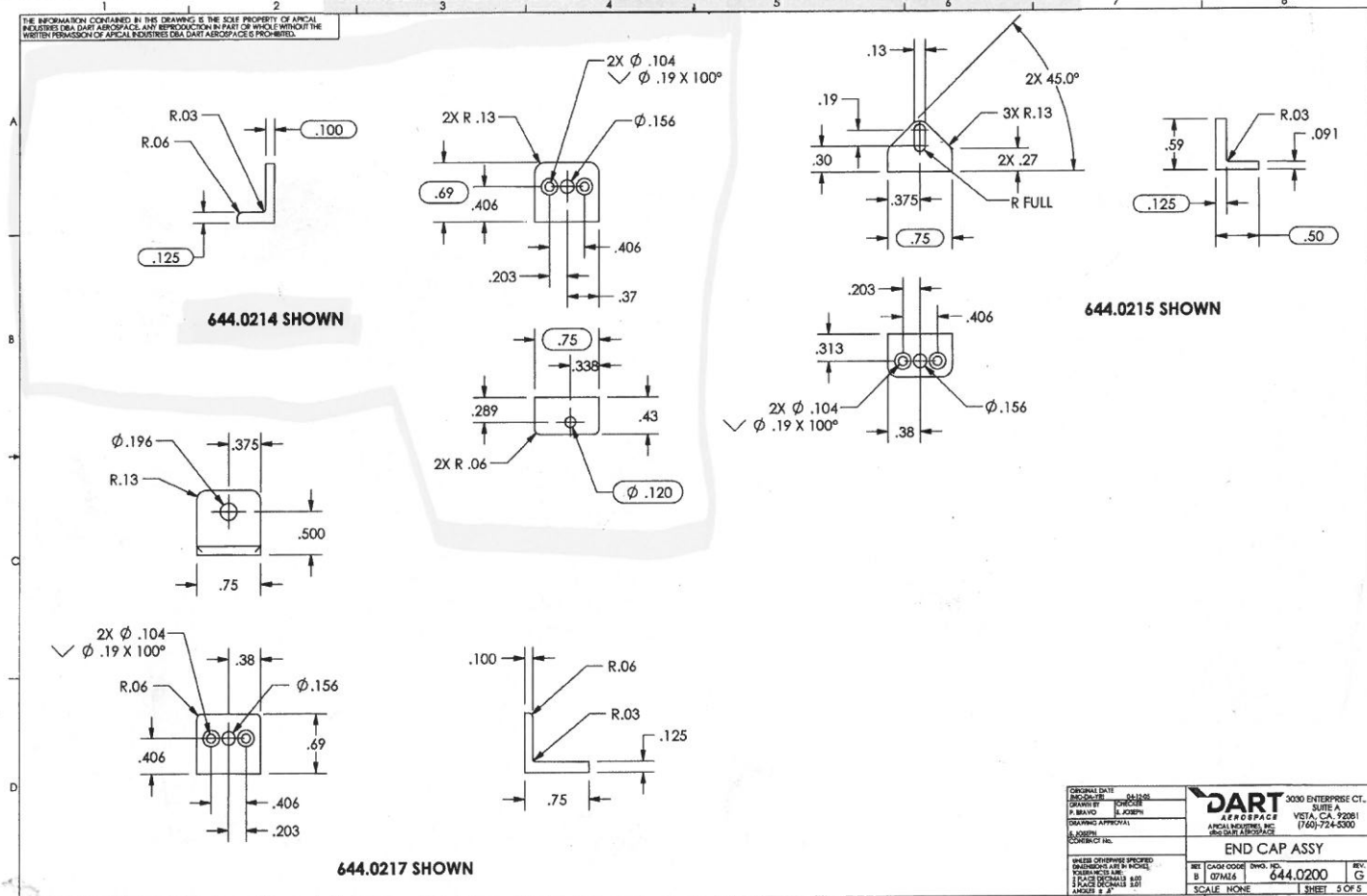
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES.



644.0212 SHOWN
644.0213 OPPOSITE

DATE	04/20/03	3030 ENTERPRISE CT.
DESIGNER	P. MAYO	SUITE A
DESIGNED BY	J. KARP	VISTA, CA 92081
DESIGNED APPROVAL		(760)-724-5300
DESIGNED		APICAL INDUSTRIES INC.
CONTACT NO.		END CAP ASSY
UNLESS OTHERWISE SPECIFIED		
DIMENSIONS ARE IN INCHES		
FINISHES ARE AS SHOWN		
SCALE	NONE	SHEET 4 OF 5

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DART AEROSPACE LTD		Work Order:	209941
Description: Inner Bracket		Part Number:	644.0205
Inspection Dwg: 644.0205	Rev: 6	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R.03	$\pm .03$	.031	✓			Vecn L910
R.06	$\pm .03$	.062				
.100	$\pm .01$	.100				
.125 .125	$\pm .01$	.127				
R.13	$\pm .03$	.120				
R.104	$\pm .004 / - .001$	.104				
$\phi .190 \times 100^\circ$	$\pm .03 \times .5^\circ$	.190 x 100°				
$\phi .156$	$\pm .005 / - .001$	.156				
.69	$\pm .03$	.690				
.406	$\pm .01$	.406				
.406	$\pm .01$	.406				
.203	$\pm .01$	.203				
.37	$\pm .03$	.375				
.75	$\pm .03$	.750				
.338	$\pm .01$	.335				
.289	$\pm .01$	.290				
R.06	$\pm .03$	.062	✓			
.120	$\pm .004 / - .001$	.119				

Measured by: <i>[Signature]</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 20/05/22	Date: 20/05/23	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046484



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046484

PO Date: 5/25/20

Due Date: 5/28/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments: **HOT HOT HOT**

E-MAILED
2020-05-27

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	210053	647.1515	647.1500 Rev E	Upper Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed X2	-	5/28/20	2 pcs	0 pcs	2 pcs	\$15.89/pcs	\$31.78
2	210051	646.9715	646.9700 Rev.J	Body : Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed X2	-	5/28/20	2 pcs	0 pcs	2 pcs	\$18.34/pcs	\$36.68

Plex 5/27/20 3:17 PM Dart.Guerin.Kimberley



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

PURCHASE ORDER

POHB046484



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
210054					Firmed	-	5/29/20	1 pcs	0 pcs	1 pcs	\$18.34/pcs	\$18.34
Sub Total:								3	0	3		\$55.02
3	209941	644.0205	644.0200 REV.G	Inner Bracket Assembly Issue P/O: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 Certification of Conformity is required	Firmed	-	5/28/20	4 pcs	0 pcs	4 pcs	\$9.59/pcs	\$38.36
4	210030	370-604031-001	370-604031-001 REV.A	Hydraulic Catch Seal Backing Plate -Issue P/O; -ANODIZE COLOR BLACK, PER MIL-A-8625 TYPE 2 CLASS 2, -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	5/28/20	4 pcs	0 pcs	4 pcs	\$11.84/pcs	\$47.36
Grand Total:												\$172.52

Sherrin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046484



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/27/20 3:17 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Pack List

Number: 920214

Date: 27-May-20

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
2 ea	Part: 647.1515 Upper deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5265778 Job: 27565 PO: POHB046484		Rev: E Expiry Date: 08/21 Line: 1
3 ea	Part: 646.9715 Body Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5265778 Job: 27566 PO: POHB046484		Rev: J Expiry Date: 08/21 Line: 2
4 ea	Part: 644.0205 Inner Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5265778 Job: 27567 PO: POHB046484		Rev: G Expiry Date: 08/21 Line: 3

DAS
81
9-89

MAY 27 2020

DART AEROSPACE LTD.

Made in Canada.

DAS
81
9-89

MAY 27 2020

DART AEROSPACE LTD.

Made in Canada.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920214

Date: 27-May-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
4 each	Part: 370-604031-001 Hydraulic Catch Seal Backing Anodize per MIL-A-8625F, Type II, Class2, Black, .0004-.0010" (4 - 1 mils) Job: 27568 PO: POHB046484	Rev: A	Line: 4
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAY 27 2020</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. RECEIVED MAY 27 2020 DART AEROSPACE LTD. Made in Canada.			